



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-87-113-3
Job Sheet 189589



Part No: RBW109-3101-87-113-3

Job Qty: 4 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3101-87-113 Rev.3 IPP Rev. A 19.01.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Conventional Lathe - 1	4 pcs	3/15/19	3/15/19	0.00	8.00	Conventional Lathe - 1	FRG 19-3-22
							Conventional Lathe - 2	
110	QC 2	4 pcs	3/15/19	3/15/19	0.00	0.00	QC 2 - 1	19/3/22
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Dart Aerospace Ltd.
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CANADA
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Container No: S165095



Part: RBW109-3101-87-113-3

Job No: 189589

Serial No/Batch: S165095

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 03/22/19

Plex 1/28/19 3:15 PM Dart.lajeunesse.marie

120	QC 8	4 pcs	3/15/19	0.00 0.00	QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	DA 19-03-23
					QC 8 - 9	
					QC 8 - 68	
130	Outsource - 13 - Zinc Plating	4 pcs	3/15/19		GRO002-VC	03/05/2019 PC
140	Packaging 2-1 - Receive - B4B	4 pcs	3/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150	QC 6	4 pcs	3/15/19	0.00 0.00	QC 6 - 38	
					QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	MAR 29 2019
					QC 6 - 61	DAS 68 9-89
160	Packaging 3-1 - Stock - B4B	4 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170	QC 21 - SA	4 pcs	3/15/19	0.00 0.00	QC 21 - SA - 21

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APR 01 2019

Part Op **100** - 1-Machine as per DWG. 2-Debur
 Descriptions: **120** - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
130 - -Issue P/O ; _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of
 Conformity is required
140 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.500	AlSI 4140 Quenched & Tempered Steel Round Bar 1.500" Dia.	.7840 ft (.196 ea)	100-Conventional Lathe - 1	500944

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	MT-4140QT-R1.500	1	7	0

Part Specifications

Specifications could not be found.

Plex 1/28/19 3:15 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

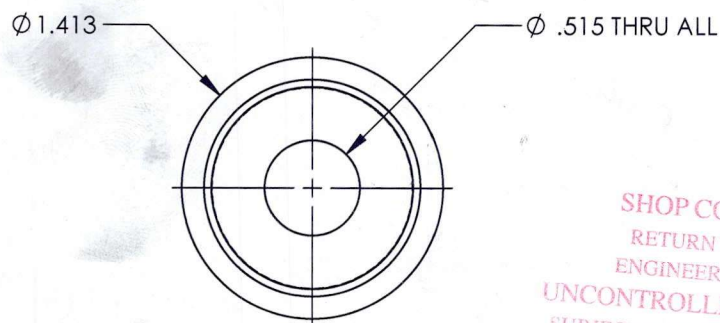
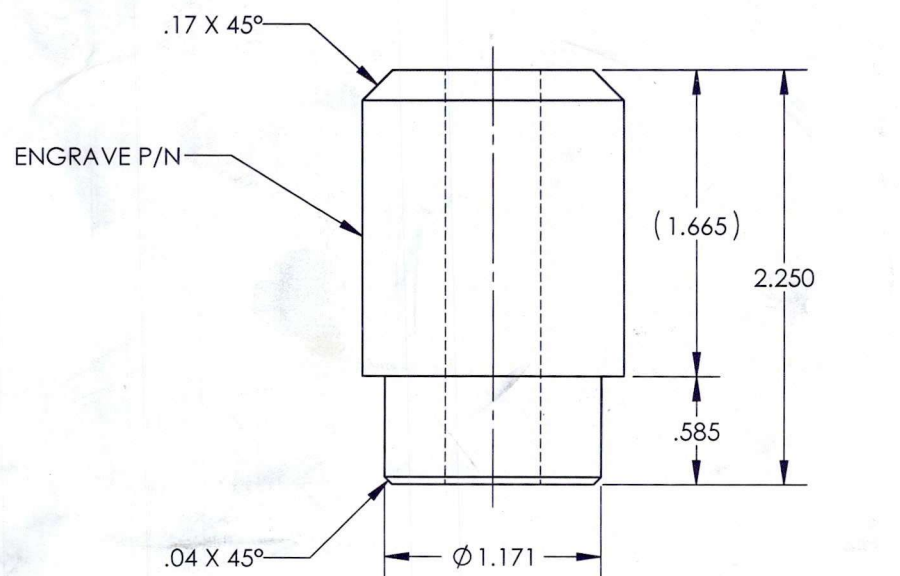
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0283	-3 CH'D ENGRAVE NOTE WAS ENGRAVE RBW109-3101-87-103 IS ENGRAVE P/N, ADDED 4142 Q&T TO MATERIAL CALL OUT.	9/1/2015	RJC	JAG
3	16-0077	-3 CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34.	7/15/2016	DEW	SM



(-3)
GUIDE

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189589 HWS
19-01-29

DART AEROSPACE	
TITLE TOOL ASSY, M/R GRIP BUSHINGS REM/INSTL	
DWG NO. RBW109-3101-87-113-3	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125/
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 X 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 2/24/2014	USED ON MODEL
	AW109, AW119
SHEET 3 OF 9	



Dart Aerospace Ltd.
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PURCHASE ORDER PO042979



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042979
PO Date: 3/25/19
Due Date: 4/1/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	189589	RBW109-3101-87-113-3	Guide -Issue P/O : _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	4/1/19	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00

4x MAR 29 2019

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Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/26/19 2:04 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(017968-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

017968- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
26-Mar-2019		Jessie Boisvert			042979				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	RBW109-3101-87-113-3 Rev.	RBW109-3101-87-113-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	4	4	0		0	0 DAS 68 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.